

ABSTRACT

In a conventional consumable electrode type welding method, owing to the need of the reversing operation of a robot manipulator, an extra response time as well as acceleration and deceleration times are necessary and, at the same time, the feed speed of a welding wire is not be able to catch up with the melting speed of the welding wire to thereby extend the length of an arc, resulting in the unstable arc. In a consumable electrode type welding method according to the invention, while feeding a welding wire 1, a welding torch 4 is moved by a robot manipulator 9 in a direction where the welding torch 4 is pulled apart from a base metal 7, so that an initial arc is generated while the welding wire 1 is separated from the base metal 7. This not only can eliminate the need for the reversing operation of the robot manipulator 9 and thus can reduce the waste time to thereby be able to reduce a tact time but also can stabilize an arc in the welding start portion and thus can reduce the "unexpected stop" effectively.